

Work Order ID 51635

August 27, 2009 8:28:13 AM



Page 1

Item ID: D3411-3

Accept



Setup Start



Revision ID: REVA

Stop



Item Name: WASHER

Start Date: 8/25/09 Start Qty: 50.00



Cust Item ID:

Required Date: 9/18/09 Req'd Qty: 50.00



Customer:

Reference:

Approvals:

Process Plan:

mtf

Date:

04 8-27

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100

0.00



Hardinge

Memo

0.00

Hardinge CNC Lathe Small

Turn as per Folio FA591 Rev: _____ & Dwg D3411 Rev: _____
Deburr & Tumble as per Dwg D3411

DIP 8/29/25

50

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

DIP 8/29/25

50

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

JK 09/09/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

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Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: 90

0.00



Packaging

Memo

0.00

Packaging

09/18/09 (SC)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/18/09

u 51-09-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 51635

Parent Item: D3411-3RevREVA

Parent Item Name: WASHER

Comments:

Start Date: 8/25/09

Required Date: 9/18/09

Start Qty: 50.00

Required Qty: 50.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MDELRLNR1.000		Purchased	No			100	f	65.0237	0.7158			



Delrin Round Bar 1"

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

65.02368421

108757

39.6936842

108804

25.33

0.7158 DIP 09/09/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

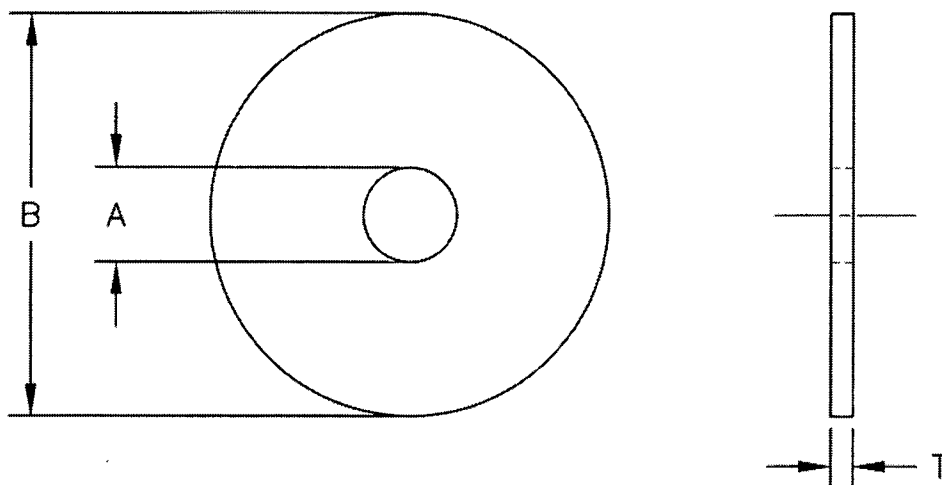
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3411	REV. A SHEET 1 OF 1
DATE 05.03.16		TITLE WASHER, DELRIN	SCALE NTS
A	05.03.16	NEW ISSUE	

SPECIFICATION CONTROL DRAWING



1) SPECIFICATION: **D3411-X, WASHER**

DASH No.

RELEASED
05.09.06 *[Signature]*

WHERE 'X' IS THE SIZE PER THE FOLLOWING TABLE:

DASH NO.	BOLT SIZE	A (in)	B (in)	T (in) ±0.006	NON-METALLIC REPLACEMENT FOR:
-3	#10	0.203	0.875	0.063	AN970-3
-4	1/4	0.265	1.125	0.063	AN970-4
-5	5/16	0.328	1.375	0.063	AN970-5
-6	3/8	0.390	1.625	0.063	AN970-6
-7	7/16	0.453	1.812	0.109	AN970-7
-8	1/2	0.515	2.000	0.109	AN970-8

57635

- 2) MATERIAL: DELRIN (DART SPEC. M-DELRIN-R)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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